

Date: Tuesday, 5/23/2006 8:36:23 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 EXTRUSION BENDING	
Job Number	: 27205		Part Number	: D2620	
Estimate Number	: 10311		Drawing Number	: D2620 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/23/2006 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/10/2006	
Previous Run	: 26863		Qty:	10 Um: Each	
Written By	: <i>SK</i> COMMENT below		Qty:	75	
Checked & Approved By	: <i>SK</i> 06.05.23		Qty:	75	
Comment	: Est. D 0207.26 Change Dwg to rev.B; Updated Location RF		Qty:	75	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26001160	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Extrusion Round 3" 206

Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	<i>B24508 DP06-5-29 15</i>

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A
 and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

DP06-5-29 15

(15)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE 06-05-29

(15)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG*

DP06-5-29

(15)

5.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

DP 06/05/30

(15)

Inspection Level 21

W 06-05-70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/05/10

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

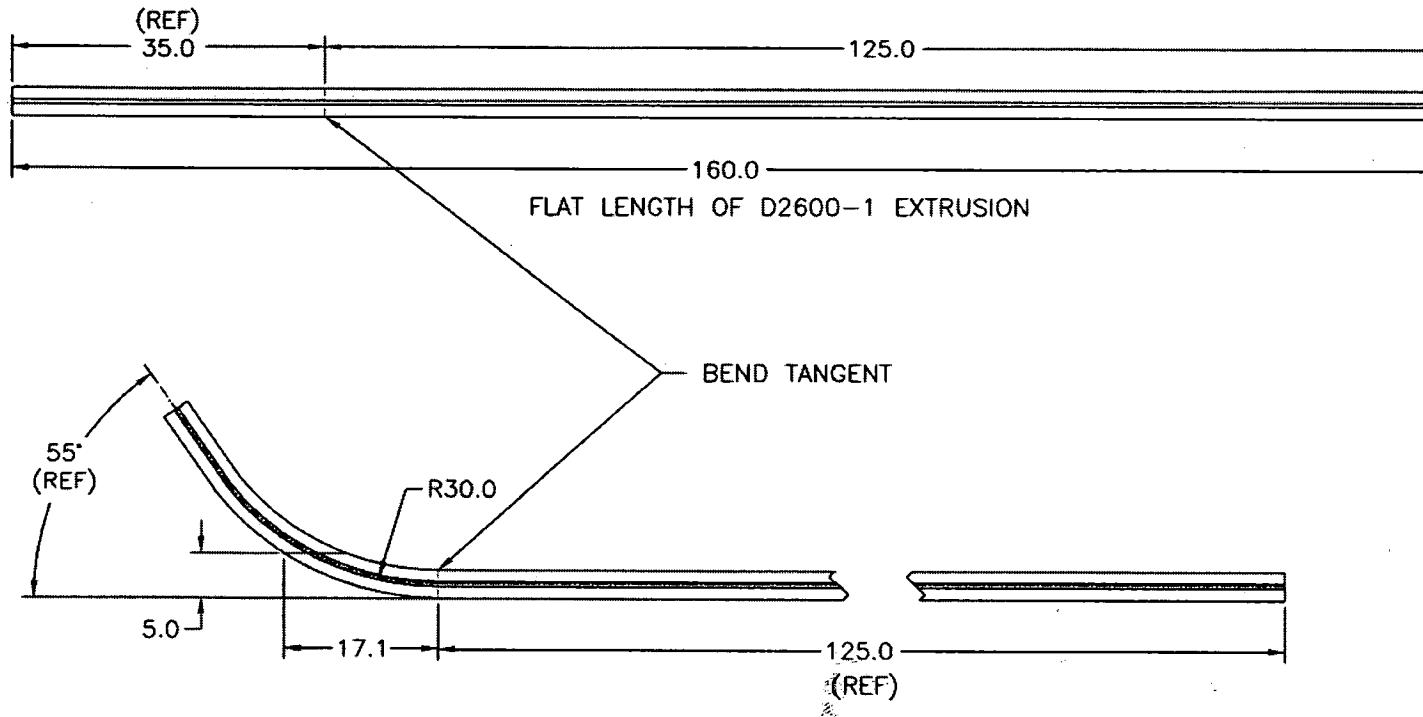
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

SPECIFICATION CONTROL DRAWING
206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.20 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.20 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
44-04-15 DS

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
checked	RF	FARCHILD INTERNATIONAL AIRPORT, WA
APPROVED	AE	DRAWING NO.
		D2620
DATE		TITLE
99.09.10		206 SKIDTUBE BENDING CONTROL
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
		SCALE
		1:20
		REV. B
		SHEET 1 OF 1

